








# Work Order ID 66209



February 7, 2011 1:16:48 PM

Page 1

Item ID: D4167-1	Accept		Setup Start	
Revision ID: PRELIM			Stop	
Item Name: Mount				
Start Date: 2/07/11	Start Qty: 2.00		Cust Item ID:	
Required Date: 2/18/11	Req'd Qty: 2.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/02/07</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4167	<u>PA1 RA4</u>								

100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
<u>6061 .063</u>	CUT AS PER DWG								
	PROG REV: <u>PA1</u>								
	DWG REV: <u>PA1</u>								
	DEBURR								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

1B 11-2-22  
1B 11-3-1

2

1B 11-2-22  
1B 11-3-1

POSITIVE  
RECALL

MATERIAL CERTIFICATION  
REQD UPON DELIVERY  
CL 01/03/04

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 66209

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Page 2

Item ID: D4167-1

Accept

Revision ID: PRELIM

Item Name: Mount

Start Date: 2/07/11

Start Qty: 2.00

Required Date: 2/18/11

Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00 - inspected to PAB



QC

Memo

0.00 Dry only

Quality Control

0.00 8/10/02 (+2)

Re-inspect to PAB Dry

only

8/10/02 (+2)

130

0.00



Small Fab

Memo

0.00

Small Fab

COUNTERSINK AS PER DWG

8/11/03/04 (+2) PAB →

140

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC


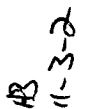
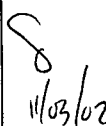


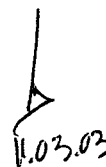

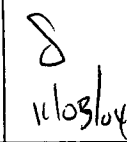
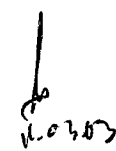
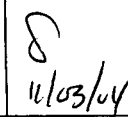
SP 01/03/04

(1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4167-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR: <u>66209</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/28	140	CRACKS FOUND WHILE BENDING THE 0.36" BEND. R.C: NO RELIEF IN PART		SCRAP + DESTROY + REPLACE WITH NEW DASKW PART. M# <u>M116623</u>	 11/03/02	 11/03/02	 11/02/28	 11/03/02
11/03/03	140	PART NOT FORMED/NOT PER DWG. RC: DWG NOT CLEAR.		SCRAP + DESTROY. ONLY QTY. 1 REQ'D.	 11/03/03	 11/03/04	 11/03/03	 11/03/04



NOTE: Date & initial all entries




# Work Order ID 66209

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Page 3

Item ID:	D4167-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Mount					
Start Date:	2/07/11	Start Qty: 2.00		Cust Item ID:		
Required Date:	2/18/11	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 - inspector to PAB Dug only Dug only							
160  Purchasing Purchasing	<del>Memo</del> ISSUE P/O: 13610 TO EAGLE COPTERS FOR FLANGING	0.00 0.00							<del>CL 11/03/04</del> (X)
170  Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs  Memo	0.00 0.00							

155 Weld as per Dwg  
AL ROD Batch: M108436

156. Q29 INSPECT WELD.  
Q40

11-03-04

11-03-04

(X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66209

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Page 4

Item ID: D4167-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Mount

Start Date: 2/07/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/04

Inspector to PAC  
Dry only

190



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

1 of 11/03/15

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M/15951

START. 1:20

Mem. QENT. 320°

FINISH 1:50

0.00

1 BR 11-3-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 66209

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Page 5

Item ID:	D4167-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Mount					
Start Date:	2/07/11	Start Qty: 2.00		Cust Item ID:		
Required Date:	2/18/11	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
220 	Identify as per dwg & Stock Location: <i>G-A</i>	0.00							
Packaging Packaging	Memo <i>w/o 66200</i>	0.00							
230 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<i>RD2334</i>

POSITIVE RECALL  
EFFECTIVE *11/02/08* AUTH *[Signature]*  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

*11-03-21*  
*(1)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

February 7, 2011 1:16:47 PM

Page 1

Work Order ID: 66209



Parent Item: D4167-1



Parent Item Name: Mount

Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-02-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	181.0000	1.6	3.368421			
6061-T6 .063 Sheet													

Location	Loc Qty	Loc Code
MAT	146.6	
116308	35.6	
116623	111	
MAT21	34.4	
113608	34.4	
<del>116268</del>		

11-2-20  
 B11-3-1  
 (2)  
 116263  
 116268

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

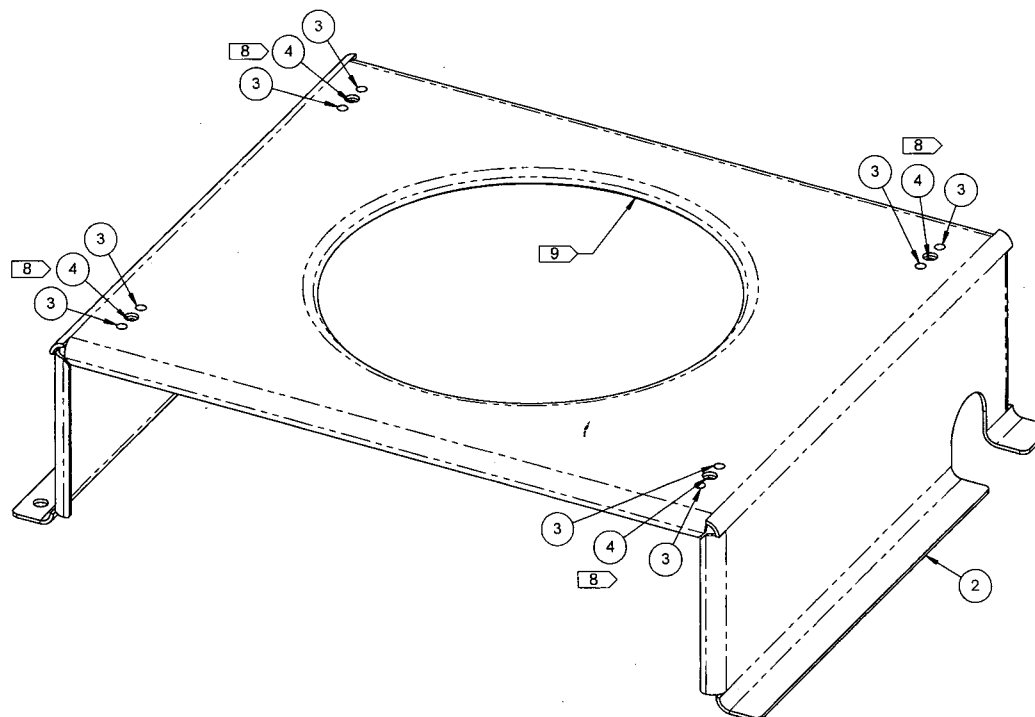
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4167-041	MOUNT ASSEMBLY
2	1	D4167-1	MOUNT
3	8	MS20426AD3-4	RIVET
4	4	MS21059-3K	ANCHOR NUT (OR MS21060L32K)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 66209

CZ11/02/07



PRELIMINARY ISSUE

10.11.17

# **D4167-041 MOUNT ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL ANCHOR NUTS AFTER POWDER COAT
- 9) PRESS FLANGE USING DT9690 FLANGING TOOL BEFORE POWDER COAT

PA4	NEW ISSUE		10.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.17		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4167** REV. PA4

SHEET 1 OF 3

TITLE **MOUNT** SCALE NTS

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Technical drawing of a rectangular plate with a central circular hole. The drawing includes the following details:

- Dimensions:**
  - Overall width: 20.75
  - Overall height: 10.37
  - Hole diameter:  $\phi 7.13$
  - Top edge thickness: 10.91, 10.71, 10.63
  - Right edge thickness: 9.75, 9.41, 9.14, 9.07, 8.52
  - Bottom edge thickness: 1.84, 1.50, 1.16, 0.28, 0.21, 0
  - Left edge thickness: 0, 0.31, 0.73, 0.91
- Material and Surface:**
  - Top edge: R0.06 4 PL
  - Left edge: R0.13 6 PL
  - Top edge:  $\phi 0.098$  8 PL
  - Top edge:  $\phi 0.246$  9 PL
  - Right edge: R0.63
- Grain Direction:** 45° (indicated by a double-headed arrow pointing towards the bottom-left corner).
- Other Features:**
  - BEND LINE TYP (indicated by a dashed line).
  - Handwritten note: "w/o bolt"

D4167-1F FLAT PATTERN

PRELIMINARY ISSUE

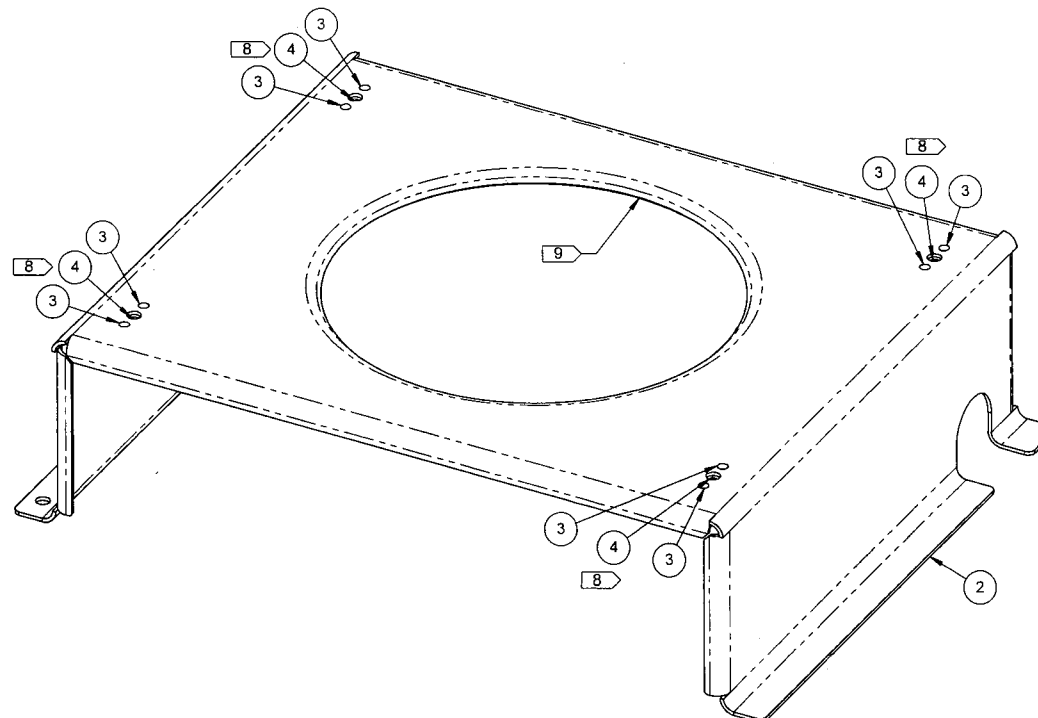
10.11.17

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063

2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.42 lbs

DESIGN	<del>15</del>	DART AEROSPACE LTD	
DRAWN	<del>15</del>	1-AKESBURY, ONTARIO, CANADA	
CHECKED	<del>15</del>	DRAWING NO.	REV. PA
MFG. APPR.	<del>15</del>	D4167	SHEET 3 OF 3
APPROVED	<del>15</del>	TITLE	SCALE
DE APPR.		MOUNT	NTS
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4167-041	MOUNT ASSEMBLY
2	1	D4167-1	MOUNT
3	8	MS20426AD3-4	RIVET
4	4	MS21059-3K	NUT PLATE



**PRELIMINARY ISSUE**

10.11.17

**D4167-041 MOUNT ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL ANCHOR NUTS AFTER POWDER COAT
- 9) PRESS FLANGE USING DT9690 FLANGING TOOL BEFORE POWDER COAT

PA5	NEW ISSUE		10.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.17		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4167** REV. PA5  
SHEET 1 OF 3  
TITLE **MOUNT** SCALE NTS

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



COUNTERSINK  $\varnothing 0.179 \times 100^\circ$   
8 PL

10.50  
REF

0.75  
TYP

12.63  
1.03.03

14.13

2 PL

0.36  
TYP

R0.19  
TYP

0.063  
REF

2 PL

3.56

**D4167-1 MOUNT**

**PRELIMINARY ISSUE**

10.11.17

**NOTES:**

- 1) MATERIAL: MADE FROM D4167-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		<b>D4167</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNT</b>	NTS
DATE	10.11.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES						
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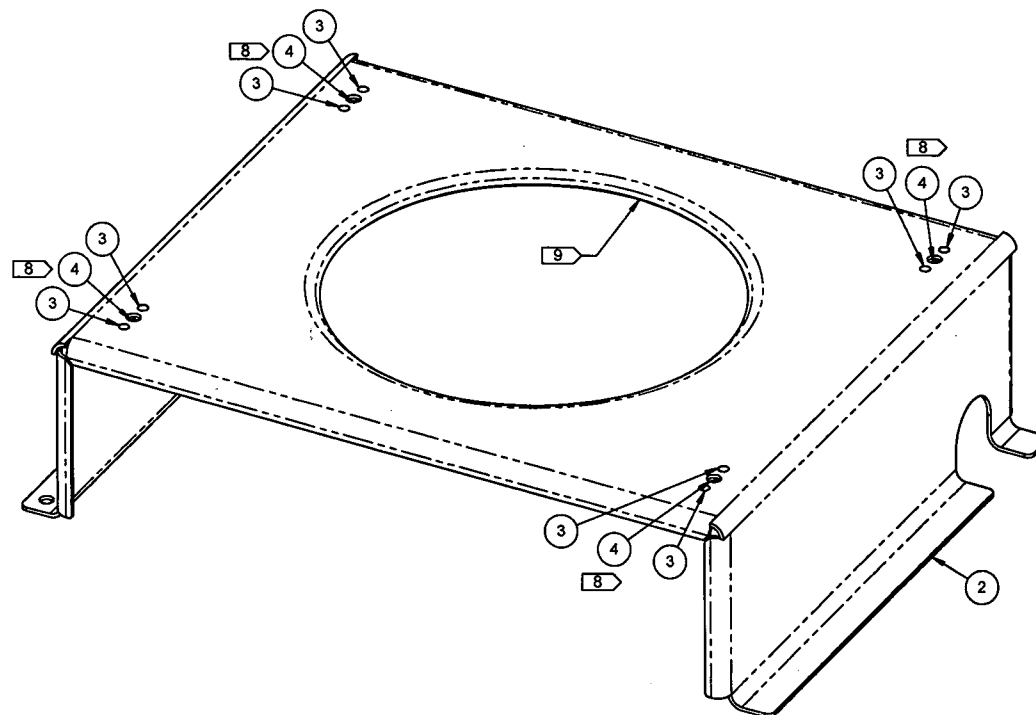
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
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2	1	D4167-1	MOUNT
3	8	MS20426AD3-4	RIVET
4	4	MS21059-3K	NUT PLATE



**PRELIMINARY ISSUE**

10.11.17

**D4167-041 MOUNT ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL ANCHOR NUTS AFTER POWDER COAT
- 9) PRESS FLANGE USING DT9690 FLANGING TOOL BEFORE POWDER COAT

PA6	NEW ISSUE		10.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.17		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. PA6

D4167 SHEET 1 OF 3

TITLE SCALE

MOUNT NTS

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COUNTERSINK  $\varnothing 0.179 \times 100^\circ$   
8 PL

10.50  
REF

0.75  
TYP

12.56  
12.63  $\pm 0.03$

14.13

0.063  
REF

2 PL

0.36  
TYP

R0.19  
TYP

3.56

**D4167-1 MOUNT**

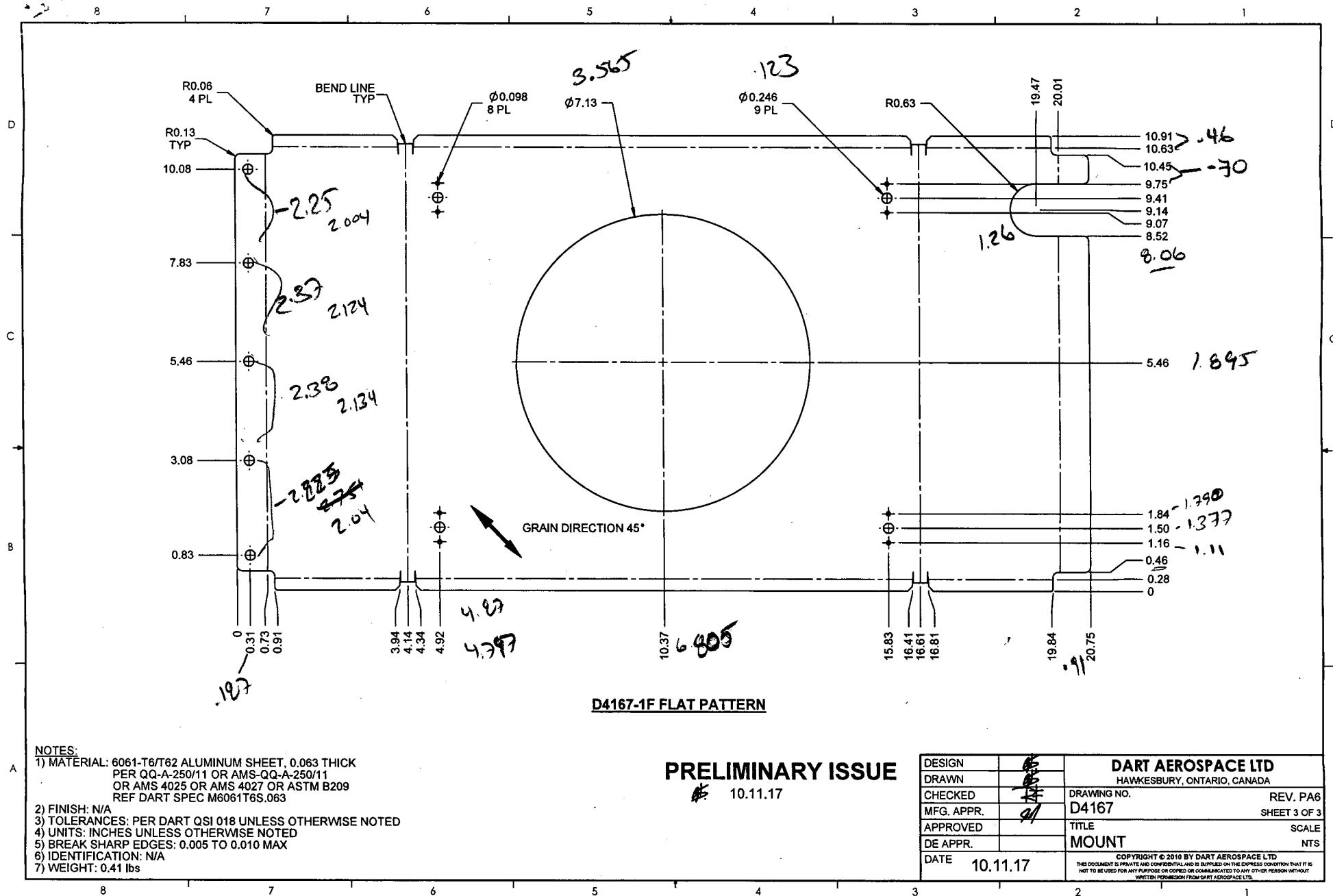
**PRELIMINARY ISSUE**

10.11.17

**NOTES:**

- 1) MATERIAL: MADE FROM D4167-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA6
MFG. APPR.		<b>D4167</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNT</b>	NTS
DATE	10.11.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DART AEROSPACE LTD		Work Order: 66209
Description: MOUNT		Part Number: D4167-1
Inspection Dwg: D4167-1 Rev: PA6		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .698	+ .004 - .001	.100	✗		V HB02	
Ø .246	+ .005 - .001	.247	✗		V	
Ø 7.13	+ .012 - .001	7.129	✗		V	
.83	+/- .030	.811	✗		V	
3.08	+/- .030	3.085	✗		V	
5.46	+/- .030	5.461	✗		V	
7.83	+/- .030	7.834	✗		V	
10.08	+/- .030	10.082	✗		PROWJ02	
10.91	+/- .030	10.917	✗		P	
10.45	+/- .030	10.456	✗		P	
9.75	+/- .030	9.755	✗		P	
9.41	+/- .030	9.413	✗		P	
9.07	+/- .030	9.069	✗		P	
8.52	+/- .030	8.524	✗		P	
5.46	+/- .030	5.46	✗		V	
1.84	+/- .030	1.848	✗		V	
1.50	+/- .030	1.503	✗		V	
1.16	+/- .030	1.158	✗		V	
.46	+/- .030	.455	✗		V	
.31	+/- .030	.313	✗		V	
.73	+/- .030	BEND	✗		V	
.91	+/- .030	.901	✗		V	
3.94	+/- .030	3.943	✗		V	

Measured by: RB	Audited by: J	Prototype Approval:
Date: 11-3-02	Date: 11/03/02	Date:

Rev A	Date	Change New Issue	Revised by KJ/JLM	Approved
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	66207
<b>Description:</b> Mount		<b>Part Number:</b>	D4167-1 (Bent)
<b>Inspection Dwg:</b> D4167	<b>Rev:</b> 126	<b>Page 1 of 1</b>	

☒ **First Article**      ☐ **Prototype**

[illegible]

Measured by:	SP
Date:	11/03/04

<b>Audited by:</b>	S
<b>Date:</b>	11/03/04

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



## Receiving Report

Date: 11/6/18 Batch No: M116623  
 Supplier: THYSSSENKRUPP Dart P/O: 13280

Packing Slip: Yes ☒ No ☐ Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Invoice: Yes ☐ No ☒ Waybill Attached: Yes ☒ No ☐ N/A ☐  
 Receipt: Cash ☐ Cr ☒ Shipment Complete: Yes ☐ No ☒ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order 15 N/A ☒

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M7075T	73B2.500V032512	0	0	0	12	

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: [Signature]  
 Date: 11/6/18  
 Received/Costing: [Signature]  
 Initial: [Signature]

Location \_\_\_\_\_

# Purchase Order Receipt Listing

Page 1 of 2

Tuesday, January 18, 2011 1:24:00 PM

All amounts are calculated in domestic currency.

All Vendors PO ID PO13280 Receipt Dates from 1/18/2011 to 1/18/2011 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name		VC-COP001 Thyssenkrupp Materials CA Ltd									
PO13280	1		M304S16GA	sf	1/19/2011	1/18/2011	256.0000	\$5.13	0.0000	0	\$1,314.05
CAD	No		304/316 Sheet .063	sf	256.0000	DESJ02		\$1,314.05	0.0000	0	
			116623								
	2		M304S20GA	sf	1/19/2011	1/18/2011	96.0000	\$3.15	0.0000	0	\$302.40
	No		304/316 .040 Sheet	sf	96.0000	DESJ02		\$302.40	0.0000	0	
			116623								
	3		M304S11GA	sf	1/19/2011	1/18/2011	64.0000	\$10.27	0.0000	0	\$657.37
	No		304/316 0.125 Sheet	sf	64.0000	DESJ02		\$657.37	0.0000	0	
			116623								
	4		M6061T6S.063	sf	1/19/2011	1/18/2011	144.0000	\$4.30	0.0000	0	\$619.20
	No		6061-T6 .063 Sheet	sf	96.0000	DESJ02		\$619.20	0.0000	0	
			116623								
	5		M304RO.750	f	1/19/2011	1/18/2011	24.0000	\$3.68	0.0000	0	\$88.20
	No		304 SS Roundbar .750	f	24.0000	DESJ02		\$88.20	0.0000	0	
			116623								
	6		M6061T6B0.500X02. f	f	1/19/2011	1/18/2011	24.0000	\$3.30	0.0000	0	\$79.20
	No		500	f	24.0000	DESJ02		\$79.20	0.0000	0	
			6061-T6 Bar .500 x 2.50	f							
			116623								
	7		M6061T6B0.750X01. f	f	1/19/2011	1/18/2011	48.0000	\$2.98	0.0000	0	\$142.99
	No		500	f	48.0000	DESJ02		\$142.99	0.0000	0	
			6061-T6 Bar .750 X 1.50	f							
			116623								
	8		M6061T6B1.000X02. f	f	1/19/2011	1/18/2011	24.0000	\$5.32	0.0000	0	\$127.60
	No		000	f	24.0000	DESJ02		\$127.60	0.0000	0	
			6061-T6 Bar 1.00 x 2.00	f							
			116623								

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-COP001	Thyssenkrupp Materials CA Ltd								
PO13280	9		M6061T6B2.000X01. f 250		1/19/2011	1/18/2011	24.0000	\$6.60	0.0000	0	\$158.40
CAD	No		6061-T6 Bar 2.00 x f 1.25 116623		24.0000	DESJ02		\$158.40	0.0000	0	
	10		M6061T6H1.000 f		1/19/2011	1/18/2011	12.0000	\$2.20	0.0000	0	\$26.40
	No		6061-T6 HexBar 1.00 f 116623		12.0000	DESJ02		\$26.40	0.0000	0	
Total Received Quantity:											716.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$3,515.81
Total Balance Due Quantity:											0.0000

SHIP FROM: B I L L O F L A D I N G  
THYSSENKRUPP MATERIALS NA  
2821 LANGSTAFF ROAD  
CONCORD, ONTARIO L4K 5C6  
Tel: 905 669 9444 Fax: 9057389033

Ship To: ( 1 )  
DART AEROSPACE  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7  
Tel: 613-632-9577 Fax: 613-632-1053

No: 1794  
Ship Date 17 Jan at 10:59 from PFW  
Probill T151240  
Via APEXMOTOR-PEC  
FOB CONCORD  
Frt PREPAID  
Route 0-40 Manifest  
Vhcle Trailer  
Slp TRINA VINCE (905-532-1365)  
Sold To: ( 20115 )  
DART AEROSPACE  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7

B I L L O F L A D I N G

1) Our Order PEC-291250- 1 Your PO # 13280  
Part # Rel # CHANTAL

MTR

STAINLESS STEEL SHEET 304-2B  
.0600 Nom X 48.0000" X 96.0000"

Heat Number Tag No  
94S54784 154576

Quantity PCS  
256.00 SFT 8

Wt LBS  
612

2) Our Order PEC-291250- 2 Your PO # 13280  
Part # Rel # CHANTAL

MTR

STAINLESS STEEL SHEET 304-2B  
.0360 Nom X 48.0000" X 96.0000"

Heat Number Tag No  
376954 154577

Quantity PCS  
96.00 SFT 3

Wt LBS  
138

3) Our Order PEC-291250- 3 Your PO # 13280  
Part # Rel # CHANTAL

MTR

STAINLESS STEEL SHEET 304-2B  
.1200 Nom X 48.0000" X 96.0000"

Heat Number Tag No  
YU257004 154578

Quantity PCS  
64.00 SFT 2

Wt LBS  
311

4) Our Order PEC-291250- 4 Your PO # 13280  
Part # Rel # CHANTAL

MTR

ALUMINUM SHEET 6061 T6  
.0640 Nom X 48.0000" X 144.0000"

Heat Number Tag No  
11649/01 154613

Quantity PCS  
144.00 SFT 3

Wt LBS  
126

Page: 1 ....Continued

FAXED

2011/01/18

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE  
RAPPORTÉES IMMÉDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.  
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

**DART AEROSPACE**

ALUMINUM SHEET 6061 T6  
0640 Nom X 48.0000" X 144.0000"  
PART NO.

PO/Rel 13280

/CHANTAL

We certify that this is a true copy of the report  
furnished by the producer of the metal, or data  
resulting from tests made in approved labs.

Signed by:



**Abnahmeprüfzeugnis 3.1 (EN 10204)**  
**Inspection certificate - mill certificate**

Nr.: 85329436 0

Rev. 0

Seite / page: 1 von 1

Datum / date: 2010 10

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, ENAS 9100, ISO 14001, NADCAP

<b>Auftraggeber / customer:</b> ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 5C6 CONCORD, ON	<b>Bestell Nr. / order no.:</b> _____ <b>Datum / date:</b> _____
<b>Warenempfänger / consignee:</b> ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 5C6 CONCORD, ON	<b>Auftragsbest. Nr. / order confirm. no.:</b> _____ <b>Datum / date:</b> _____
<b>Endkunde, Bestell-Nr. / Your cust., ord. no.:</b> _____	<b>Lieferschein Nr. / delivery note:</b> _____ <b>Datum / date:</b> _____ <b>Akkreditiv Nr. / letter of credit no.:</b> _____

<b>Produkt/product:</b> Form / form: Sheet Werkstoff / material: 6061 Zustand / temper: T6 Dim. / dim: [inch]: 0,063x48,00x144,00 Kundenartikel-Nr / customer article no.: _____	<b>Bedingungen/terms:</b> Techn. Lieferbedingungen / techn. spec.: AMS-QQ-A-250/11, 08.1987 ASTM B 209 - 07 Material meets also the mech. properties of AM 07.2008, but not marked ANSI H35.2-2009 ASME SB 209, 2007  Sondervorschrift / special terms: _____
---	--

AB-Pos. ord. item:	BNr/Los/Tellos Lot/No./Part	Guss-Nr. cast no.	Werkstoff material	Kollo pack no.	Gewicht netto weight net
01	11649/01/00	80/0068011/0	6061.1	6187470001	4007,937 lbs

**Chemische Zusammensetzung / chemical composition: [%] Gewichtanteile / weight proportion**

Guss Nr. / cast no.	AMAG designation	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
80/0068011/0	6061.1									
	actual	0,63	0,45	0,21	0,08	0,82	0,16	0,01	0,03	0,01

**Zugversuch / Tensile test**

BNr/Los Lot/No.	Zustand temper	Richtung direction	Rm [ksi]	Rp0.2 [ksi]	A2" [%]
11649/01	T6	LT	47,1	39,3	16
11649/01	T6	LT	46,0	39,2	18
11649/01	T6	LT	46,7	38,9	16
11649/01	T6	LT	46,7	39,0	16
11649/01	T6	LT	46,8	39,2	16

# THYSSENKRUPP MATERIALS NA

## DART AEROSPACE

ALUMINUM SHEET 6061 T6  
0648 Norm X 49.0000" X 144.0000"  
PART NO.

PO/Ref 13280

/CHANTAL

## Certificate of Mill Test Results

BL PEC-691794-004 17Jan11

Pg 2/2

We certify that this is a true copy of the report  
furnished by the producer of the metal, or data  
resulting from tests made in approved labs.

Signed by



### Abnahmeprüfzeugnis 3.1 (EN 10204) Inspection certificate – mill certificate

Nr.: 85329436 01 / 5

Rev. 0

Seite / page: 2 von / of 2

Datum / date: 2010 10 18

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, ENAS 9100, ISO 14001, NADCAP

Es wird bestätigt, dass die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellung entspricht.  
We hereby certify that the material described above has been tested and complies with the terms of the order contract.

Werkssachverständiger / factory specialist	E-Mail / e-mail
Josef Klampl	j.klampl@amag.at

Herstellerland: Österreich / goods origin: The goods are of Austrian origin.  
Maschinell erstellt - Gültig ohne Unterschrift / Automated - valid without being signed.

AMAG rolling GmbH, Postfach 32, A-5282 Ranshofen, Österreich – [www.amag.at](http://www.amag.at)  
AMAG rolling GmbH, P.O. Box 32, A-5282 Ranshofen, Austria – [www.amag.at](http://www.amag.at)